

Work Order ID 54720 - 1

December 17, 2009 8:51:04 AM



Page 1

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 30/12/2009 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *RL*

QC:

Date: *09-17*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2360

Rev D

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: 12.65" Long

0.00

0.00

OK 09/12/19

6 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio D2341 and Dwg D2341
2-Debur

0.00

0.00

OK 09/12/19

6 0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

OK 09/12/19

6 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54720

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Page 2

Item ID: D2360

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Tie Down Assembly

Start Date: 17/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

H. A 09/12/21

6

φ

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

BL 09-12-22

6

φ

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

BL 09-12-22

6

φ

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30
OVEN TEMPERATURE: 330
FINISH TIME: 11:00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 30/12/2009 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

09-12-22

X6

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Assemble as per dwg D2360

EP 10/01/11

Small Fab

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

EP 10/01/11

HL

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 54720

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Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 17/12/2009 Start Qty: 6.00

Required Date: 30/12/2009 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

200

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



10-1-11

10/01/12

10/01/12
MUF 10-1-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 17, 2009 8:51:08 AM

Page 1

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly


Start Date: 17/12/2009

Required Date: 30/12/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6201		Manufactured	No			100	f	20.0000	6.6568			
<div>  </div>												
"T" Extrusion												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

20

45500

20

170

Each

471.0000

6.0000

AN526C1032R18

Purchased

No



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

471

101458

83

108079

194

4523

194

6.6568 mk 09/12/19
10-1-5 (CR) SL

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly


Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No			170	Each	1,540.000	12.0000			
												
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1540	
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	48	
112314	228	
112369	22	
113149	1000	

AN960JD10L

Purchased

No

170

Each

5,269.000 48.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	5269	
101291	16	
104885	153	
105793	236	
109632	250	
110985	4614	

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 3

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2002-015



Knob

Manufactured No

170

Each

84.0000

12.0000



10-1-5

SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

16177

69

39056

15

12

D2345



Lock Channel

Manufactured No

170

Each

12.0000

6.0000



10-1-5

SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

39474

12

6

D2366



Lock Handle

Manufactured No

170

Each

27.0000

12.0000



10-1-5

SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

37431

1

42919

26

17

December 17, 2009 8:51:08 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

December 17, 2009 8:51:08 AM

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly



Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2367		Manufactured	No			170	Each	18.0000	6.0000			
												
Handle Knob												

10-1-5 sl


Warehouse
Location
Main Warehouse

D2372



Quick Release

Manufactured No

<u>Loc Qty</u>	<u>Loc Code</u>
18	
2	
16	
170	
Each	
10.0000	12.0000
	

2
4

10-1-5 sl


Warehouse
Location
Main Warehouse

D2373



Spring

Manufactured No

<u>Loc Qty</u>	<u>Loc Code</u>
10	
10	
170	
Each	
25.0000	6.0000
	

1

10-1-5

sl (62)

Warehouse
Location
Main Warehouse

<u>Loc Qty</u>	<u>Loc Code</u>
25	
5	
20	

5
1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 17, 2009 8:51:08 AM

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly



Comments:

Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2444		Manufactured	No			170	Each	11.0000	6.0000			
												
Pip Pin Assembly												

10-1-5 sl

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

11

43978

1

45387

2

54533

8

170

Each

11,763.00

6.0000

10-1-5

sl (60)

MS20470AD3-4

Purchased

No



Rivet, Universal Head

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

11763

111477

8332

15541

3431

10-1-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 17, 2009 8:51:08 AM

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Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly


Comments:

Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			170	Each	2,489.000	18.0000			
												
Nut												

10-1-5 *sl*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2489	
110844	35	
111274	27	
111668	64	
112314	1863	
112385	500	

MS27039-1-13 Purchased



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	109	
105211	9	
110844	100	

10-1-5

sl (6)

December 17, 2009 8:51:08 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 17, 2009 8:51:09 AM

Work Order ID: 54720

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Comments:

Start Date: 17/12/2009

Required Date: 30/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	B/ Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Re- maining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	------------	---------------------	------------------	-----------------	--------------------	----------------	-------------------------------	---------------	----------------	--------

MS27039-1-15

Purchased

No

170

Each

163 0000

12 0000



Screw

10-1-5 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

163

106903

3

108169

4

109321

4

111916

52

112794

100

NAS679A3W

Purchased

No

170

Each

244 0000

6 0000



Nut

10-1-5 (C) SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

244

1463

51

2409

193

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.503	—			
1.000	+/-0.010	1.000	—			
Ø0.242	+0.005/-0.001	Ø.244	—			
Ø0.191	+0.005/-0.001	Ø.195	—			
R0.250	+/-0.010	R.250	—			
1.700	+/-0.010	1.752	—			
0.750	+/-0.010	.750	—			
2.750	+/-0.010	2.752	—			
11.000	+/-0.005	11.000	—			
5.500	+/-0.010	5.500	—			
1.584	+/-0.010	1.586	—			
Ø0.191	+0.005/-0.001	Ø.195	—			
2.610	+/-0.010	2.611	—			
0.844	+/-0.010	.844	—			
1.250	+/-0.010	1.251	—			
0.750	+/-0.010	.752	—			
12.500	+/-0.010	12.500	—			
3.313	+/-0.010	3.314	—			
4.250	+/-0.010	4.252	—			
0.400	+/-0.010	.400	—			

Measured by:	<i>[Signature]</i>
Date:	09/12/21

Audited by:	NA
Date:	09/12/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**

07 06 07

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34720

13/09/12-17

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

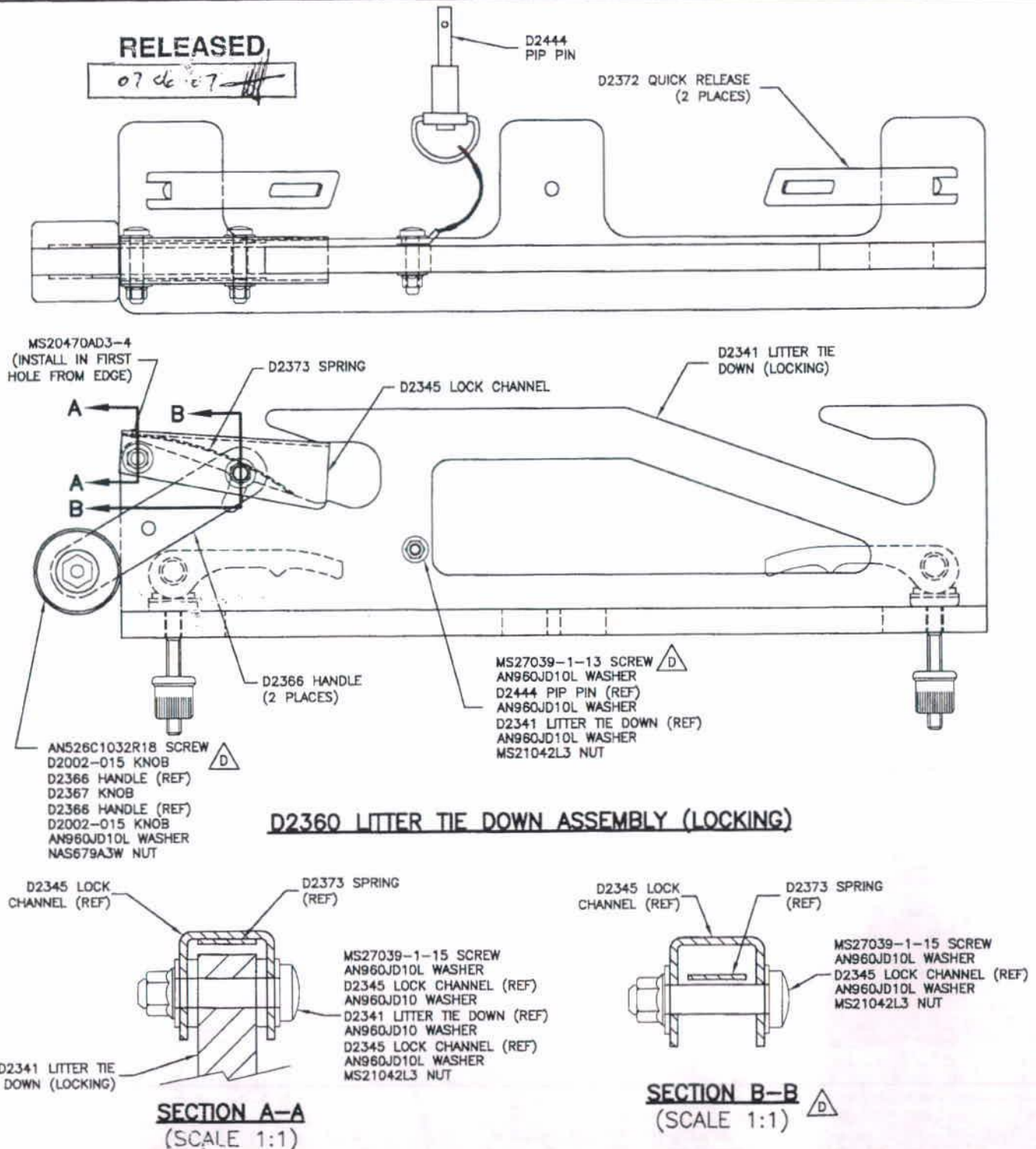
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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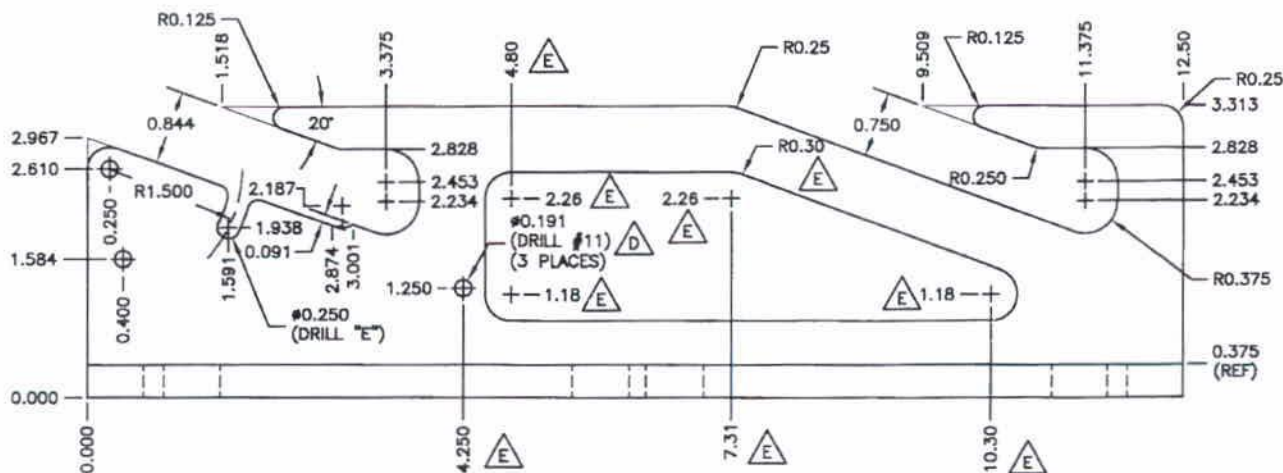
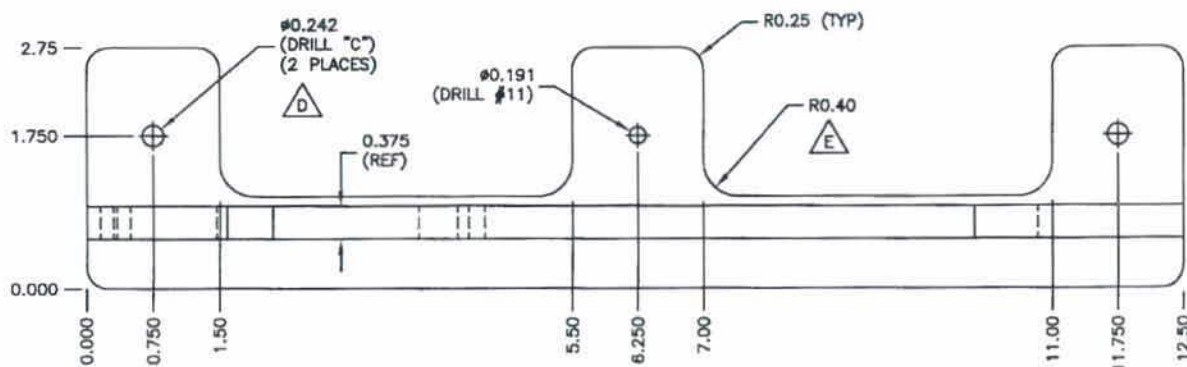
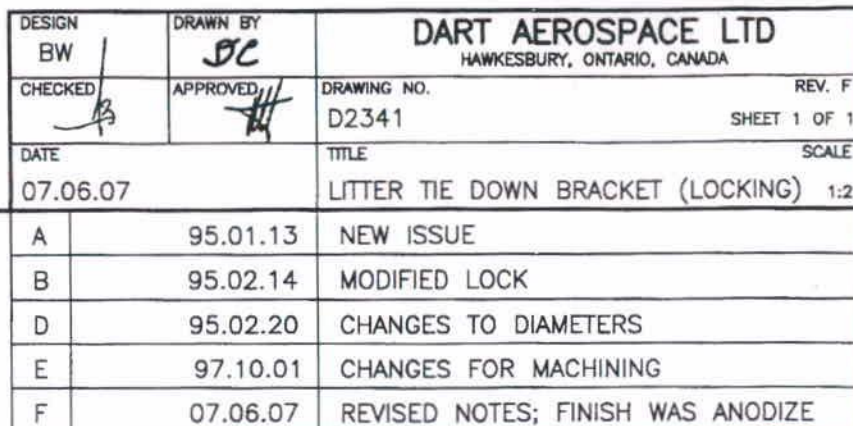
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE



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D2341 LITTER TIE DOWN BRACKET (LOCKING)

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
(6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT
PERMANENT INK MARKER

RELEASED

07.06.22

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